

Date: Wednesday, 18/06/2008 1:27:54 PM  
User: Julie Lecocq

## Process Sheet

Split WO  
SB 08/07/17

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 39935  
Estimate Number : 13032  
P.O. Number :  
This Issue : 18/06/2008 S.O. No. :  
Prsht Rev. : NC  
First Issue : 1/1 Type : SMALL /MED FAB  
Previous Run : 37142  
Written By :  
Checked & Approved By : JUD 08-6-18  
Comment : Est Rev:A New Issue 07-09-27 DD verified by: EC  
Est Rev:B ECN 1113P 08-01-22 DD  
Est Rev:C ecn1162 08-04-02 DD verified by: EC

Drawing Name : FLANGE ASS'Y  
Part Number : D3651043  
Drawing Number : D3651 REV.B  
Project Number : N/A  
Drawing Revision : B  
Material :  
Due Date : 07/07/2008 Qty: 2 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S26GA 304/316 0.018 SHEET



Comment: Qty.: 0.2573 sf(s)/Unit Total: 0.5145 sf(s)

304/316 SS sheet 26 ga (0.018" thick)

Batch: 108415 HB 8-6-26

(FOR D3651-7)

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3651 (D3651-7)

Dwg Rev: B

Prog Rev: B

HB 8-6-26

2-Deburr if necessary

IDENTIFY AS D3651-7

HB 8-6-26

(3)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



HB 8-6-26



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



06-27 (3)



Comment: SECOND CHECK



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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLANGE ASSY

Job Number: 39935

Part Number: D3651043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

M304S26GA

304/316 0.018 SHEET



Comment: Qty.: 0.2573 sf(s)/Unit Total: 0.5145 sf(s)

304/316 SS sheet 26 ga (0.018" thick)

Batch: 108415 B 8-7-2

(FOR D3651-5)

6.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3651 (D3651-5)

Dwg Rev: B

Prog Rev: B

B 8-7-2

(3)

2-Deburr if necessary

Identify as D3651-5

B 8-7-2

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



B 8-7-2

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

8.0

QC8

SECOND CHECK



Comment: SECOND CHECK

5 08/07/02 (x3)

9.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form D3651-5 and D3651-7 as per Dwg D3651

5 08-07-09 (3)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/07/02 (x3)

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld assembly as per dwg D3651

11 08-07-10 (3)





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Drawing Name: FLANGE ASS'Y

Job Number: 39935

Part Number: D3651043

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

14.0

D36513

Base



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

BASE **B40193**

15.0

MS20427M33

Rivet



Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)

Rivet **M106993**

FF 08-07-21 ①

16.0

MS210603K

Nut Plate



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Nut Plate **M105938**

FF 08-07-21 ①

17.0

CR3523401

RIVET



Comment: Qty.: 57.0000 Each(s)/Unit Total : 114.0000 Each(s)

RIVET **M106375**

FF 08-07-21 ①

18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D3651

FF 08-07-21 ①

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/2/21 ④



## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLANGE ASS'Y

Job Number: 39935

Part Number: D3651043

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock

Location: GA

S/S 08/07/21 ①

21.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/30

Job Completion



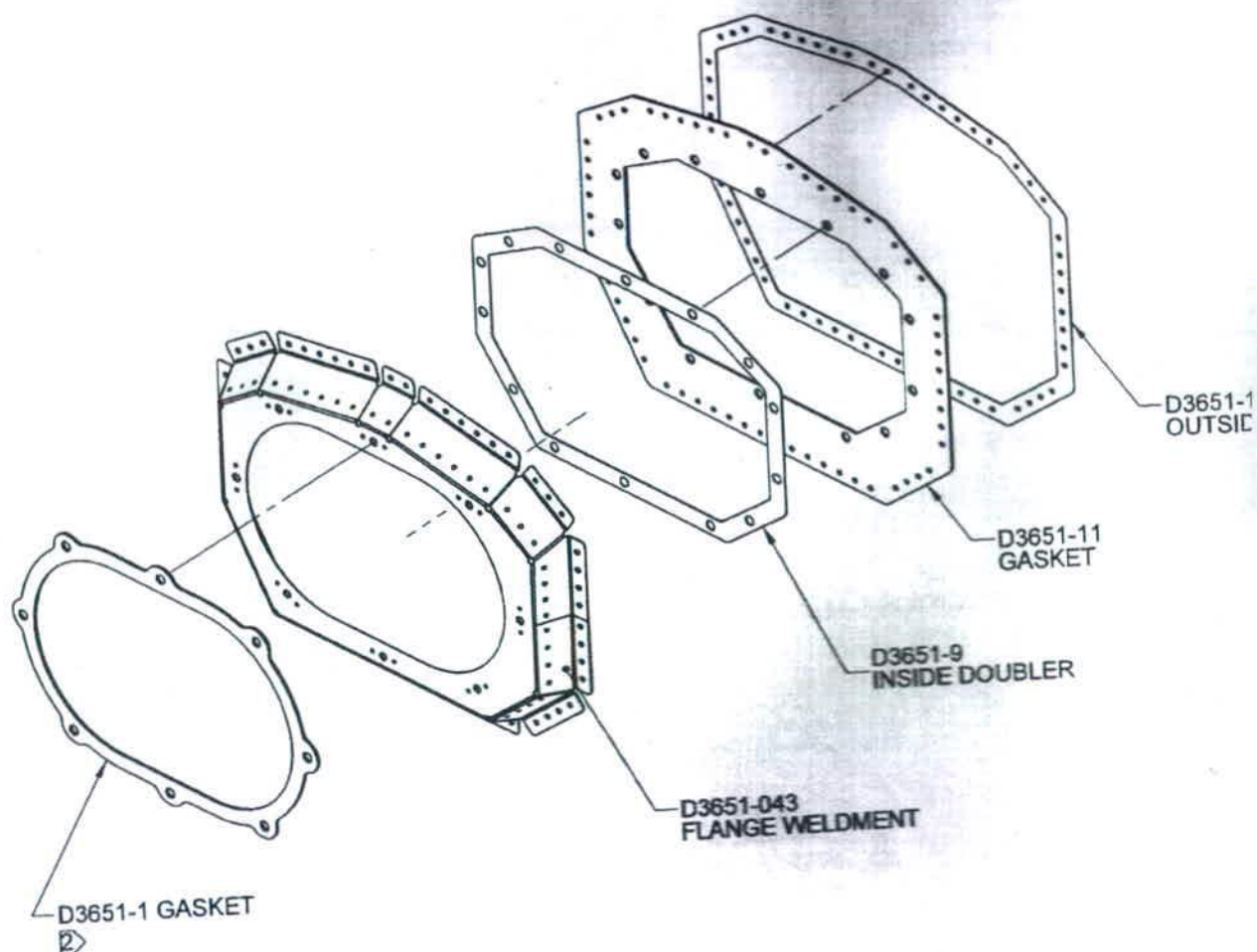
MF 08-07-29











# **D3651-041 AFT BASE /**

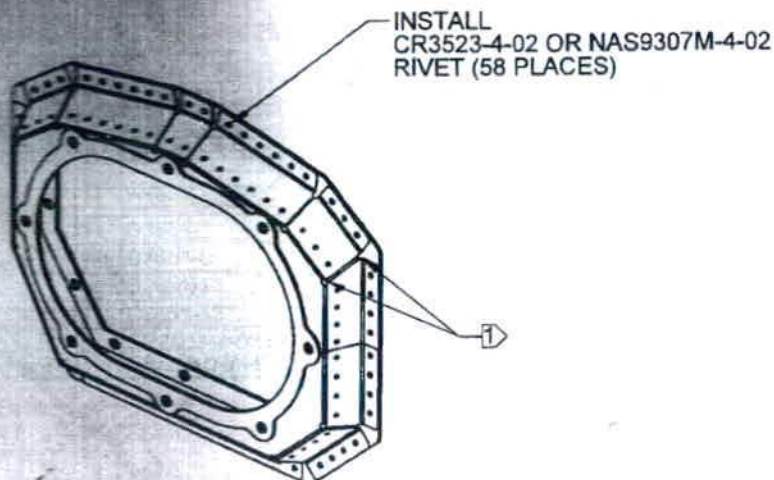
## **D3651-041 NOTES:**

- 1) SEAL ALL MATING SURFACES AND GAPS USING PROSEAL 700 FIRE WALL SEALANT
- 2) INSTALL D3651-1 USING 3M HIGH PERFORMANCE CONTACT ADHESIVE 1357
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.6 lbs





DOUBLER



PART LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3651-041	AFT BASE ASSEMBLY
1	D3651-043	FLANGE WELDMENT
1	D3651-1	GASKET
1	D3651-9	INSIDE DOUBLER
1	D3651-11	GASKET
1	D3651-13	OUTSIDE DOUBLER
58	CR3523-4-02 or NAS9307M-4-02	RIVET

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 37932

RELEASED  
08.03.27

MBLY

B	SHEET 1: GENERAL UPDATE SHEET 2: 8.74 WAS 8.50; 0.88 WAS 0.98; REMOVED ANGLE SHEETS 4, 5, 6, 8 & 9: GENERAL DIMENSIONAL UPDATE SHEET 7: 5.514 WAS 5.504		RF	08.01.07
A	NEW ISSUE		RF	07.11.07
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF			
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		D3651	SHEET 1 OF 9	
APPROVED		TITLE	SCALE	
DE APPR.		AFT BASE ASSEMBLY	1:4	
DATE	08.01.07		COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

